

AS.AP.

Work Order ID 162960

162960

Page 1

Monday, June 19, 2017 11:36:42 AM

Item ID: D066-1016-115 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: R66 Basket Mounting Provisions
Start Date: 6/26/2017 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 6/30/2017 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: [Signature] Date: JUN 19 2017 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D066-1016	B	JUN 19 2017		6					

100 Document Control 0.00
100
DC DOCUMENT CONTROL
Memo 0.00
Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D066-1016-115 CHG001

DAS
27
9-89

JUN 21 2017

110 Pick Kit 0.00
110
Packaging Memo 0.00
Packaging

DAS
6
9-89
DAS
28
9-89
JUN 21 2017

120 QC4- 100% Inspect kits for completeness 0.00
120
QC Memo 0.03
Quality Control

DAS
27
9-89
JUN 21 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Work Order ID 162960

Monday, June 19, 2017 11:36:42 AM

162960

Page 2

Item ID: D066-1016-115

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: R66 Basket Mounting Provisions

Start Date: 6/26/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/30/2017 Req'd Qty: 1.00

1

Customer:

Reference:

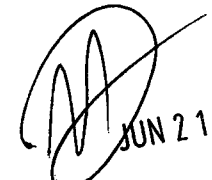
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D066-1016-115 Location: PPPS9412								
						DAS			
						27			
						9-89			
									JUN 21 2017
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									17/6/21


JUN 21 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : ☐						
Misidentified ☐	☐	Past Due ☐							

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Page 1

162960

D066-1016-115

Required Date: 6/30/2017

Required Qty: 1.00

Comments: IPP REV:A 16.01.14 NEW ISSUE DD VERF:JLM IPP
REV:B 17.03.28 as per iin rev.b DD VERF:RO

AN4-12A
AN4-12A
Bolt

DAS
27
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	10	
120423	10	
ST344	102	
m137412	102	

D5350-041
D5350-041
 Fwd Cross Beam Assembly

DAS
27
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST260B	3	
159889	3	

D5350-043
D5350-043
Aft Beam Assembly

DAS
27
9-80

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST260B	3	
159891	3	

D5352-1
9-80
D5352-1
Cushion

**DAS
27
9-88**

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST515	116	
159892	100	
161553	16	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Work Order ID: 162960

162960

Parent Item: D066-1016-115

D066-1016-115

Parent Item Name: R66 Basket Mounting Provisions

Start Date: 6/26/2017

Required Date: 6/30/2017

Start Qty: 1.00

Required Qty: 1.00

D5354-041 Manufactured No

110 Each

0.0000

1 1

DAS

DAS

D5354-041

R66 Fwd Clamp Assembly, LH

D5354-042 Manufactured No

110 Each

2.0000

1 1

DAS

DAS

D5354-042

R66 Fwd Clamp Assembly, RH

Location

Loc Qty

Loc Code

ST516

2

158807

2

D5355-041 Manufactured No

110 Each

4.0000

2 2

DAS

JUN 20 2017

D5355-041

Aft Clamp Assembly

Location

Loc Qty

Loc Code

ST516

4

158809

4

D5358-1 Manufactured No

110 Each

6.0000

2 2

DAS

JUN 20 2017

D5358-1

Cover Plate

Location

Loc Qty

Loc Code

ST516

6

159085

6

D5445-041 Manufactured No

110 Each

2.0000

1 1

DAS

JUN 20 2017

D5445-041

Longitudinal Beam Assembly, LH

Location

Loc Qty

Loc Code

ST260B

2

159651

2

Monday, June 19, 2017 11:36:42 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

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Work Order ID: 162960

162960

Parent Item: D066-1016-115

D066-1016-115

Parent Item Name: R66 Basket Mounting Provisions

Start Date: 6/26/2017

Required Date: 6/30/2017

Start Qty: 1.00

Required Qty: 1.00

D5445-042 Manufactured No

110 Each 2.0000

DAS

D5445-042

Longitudinal Beam Assembly, RH

**

6

DA

28

9-89

JUN 20 2017

Location

Loc Qty

Loc Code

ST260B

2

159649

2

MS20392-4C57

Purchased No

110 Each 26.0000

**

JUN 20 2017

DAS

6

DAS

28

9-89

Pin

MS20392-4C57

Location

Loc Qty

Loc Code

ST312

26

m137361

26

MS24665-229

Purchased No

110 Each 177.0000

**

JUN 20 2017

DAS

6

DAS

28

9-89

Cotter Pin

MS24665-229

Location

Loc Qty

Loc Code

GA

2

118234

2

ST289

175

m135671

175

MS27151-7

Purchased No

110 Each 28.0000

**

JUN 20 2017

DAS

6

DAS

28

9-89

MS27151-7

PAL NUT

Location

Loc Qty

Loc Code

ST275

28

m134055

4

m137361

4

m137459

20

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>								Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																								
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																								
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																								
Large Fab ☐	Composite ☐	Supplier ☐																									
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																			
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																			
Root Cause		FAULT CATEGORY																									
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐													
		OTHER : ☐																									

Picklist Print

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Work Order ID: 162960

162960

Parent Item: D066-1016-115

D066-1016-115

Parent Item Name: R66 Basket Mounting Provisions

Start Date: 6/26/2017

Required Date: 6/30/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

4,030.000

8

8

NAS1149D0463J

Washer

**

DAS
6
9-88

JUN 20 2017

DAS
28
9-88

Location

Loc Qty

Loc Code

GA

40

M135056

40

ST260a

2000

M137699

2000

ST263

1990

M137371

1988

M137544

2

110

Each

130.0000

4

4

**

DAS
6
9-88

JUN 20 2017

DAS
28
9-88

NAS1149F0563P

Purchased

No

NAS1149F0563P

Washer

Location

Loc Qty

Loc Code

ST262

130

m136983

130

DAS
27
9-89

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Shop Packet Print

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

5.0 PARTS LIST

Qty -011	Qty -012	Qty -111	Qty -113	Qty -115	Qty -121	Qty -123	Part Number	Description
X							D066-1016-011	R66 QR HELI-UTILITY-BASKET, LH
	X						D066-1016-012	R66 QR HELI-UTILITY-BASKET, RH
		X					D066-1016-111	CROSSTUBE CLAMP KIT
			X				D066-1016-113	CROSSTUBE CLAMP + LONGITUDINAL BEAM KIT
1	1			X			D066-1016-115	BASKET MOUNTING PROVISIONS KIT
					X		D066-1016-121	FWD LID GAS SPRING UPGRADE (OPTIONAL)
						X	D066-1016-123	FWD FIXED STEP UPGRADE (OPTIONAL)
1							D5337-011	BASKET ASSEMBLY, LH
	1						D5337-012	BASKET ASSEMBLY, RH
					2		D3953-17	GAS SPRING SPACER
					1		D3953-19	GAS SPRING BRACKET
					1		D3953-21	GAS SPRING BRACKET
					2		D3953-3	GAS SPRING STUD
					2		D3953-7	GAS SPRING SPACER
					2		D3953-9	GAS SPRING WASHER
					1		D3969-7	GAS SPRING
				1			D5350-041	R66 FWD CROSS BEAM ASSEMBLY
				1			D5350-043	R66 AFT CROSS BEAM ASSEMBLY
		4	4	4			D5352-1	CUSHION
		1	1	1			D5354-041	R66 FWD CLAMP ASSEMBLY, LH
		1	1	1			D5354-042	R66 FWD CLAMP ASSEMBLY, RH
		2	2	2			D5355-041	R66 AFT CLAMP ASSEMBLY
1	1						D5357-041	STRUT ASSEMBLY
		2	2	2			D5358-1	COVER PLATE
			1	1			D5445-041	LONGITUDINAL BEAM ASSEMBLY, LH
			1	1			D5445-042	LONGITUDINAL BEAM ASSEMBLY, RH
						1	D5510-041	FWD STEP
					2		AN310C4	NUT, CASTELLATED
					4		AN3-14A	BOLT
			8	8			AN4-12A	BOLT
						2	AN4-14A	BOLT
				4			MS20392-4C57	PIN
					4		MS21042L3	NUT
						2	MS21042L4	NUT
				4			MS24665-229	COTTER PIN
					2		MS24665-300	COTTER PIN
		8	8	8			MS27151-7	STAMPED NUT
					2		NAS1149C0432R	WASHER
			8	8		4	NAS1149D0463J	WASHER
				4			NAS1149F0563P	WASHER
					8		NAS1149F0332P	WASHER

Work Order ID 162960

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Page 1

Item ID: D066-1016-115

Accept

N19000040100

Setup Start *NS1*

Revision ID:

Item Name: R66 Basket Mounting Provisions

Stop *NS2*

Start Date: 6/26/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/30/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: JUN 19 2017 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	JUN 19 2017							
IIN-D066-1016	B								
100	Document Control	0.00				DAS 39 9-89			
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D066-1016-115 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									

JUN 20 2017